Date: Wed	nesday, 10/31/2007 3:26:10 PM	/			-
User: Kim	Johnston	Proce	ss Sheet		
Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approv Comment	: 29328	MALL /MED FAB  7.     O   Re-format DM	Drawing Name  Part Number  Drawing Number  Project Number  Drawing Revision  Material  Due Date	: FORWARD CAP  : D2647 : D2647 REV F : N/A : F : : 12/5/2007 Qty:	100 Um: Each
Additional Produc	t			.,	f
Job Number:				NOT SIM.	÷
Seq. #:	Machine Or Operation:		Description :		
1.0	M6061T6S080	6061-T6 .			
	ent: Qty.: 0.1677 sf(s)/Unit Material:6061-T6 QQ-A-250			Batch_(00 947	1B 07-11-5
2.0		FLOW W <i>j</i>	ATER JET		
Comm	ent: FLOW WATER JET  1-Cut as per Dwg D2647  Dwg Rev:  Prog Rev:	07-11-5		(DS)	
3.0	2-Deburr if necessary	HB 87-11-E	PARTS AS THEY COME	OFF MAQUINIF	·
		B 07-11-5	FARTS AS THE COME	OFF MACHINE	
	ent: INSPECT PARTS AS THE		· · · · · · · · · · · · · · · · · · ·		
4.0	QC8	SECOND	CHECK		sails
	ent: SECOND CHECK	<u> </u>	2/4/05	(175)	
5.0	SMALL FAB 1	M	MEDIUM FAB RESOURC		
Comme	ent: SMALL & MEDIUM FAB RE Deburr	SOURCE T	M SHIPE C	de Alutes	
		<del></del>	·		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHA	NGE By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C				
				·						
		·								

Wednesday, 10/31/2007 3:26:10 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: FORWARD CAP Customer: CU-DAR001 Dart Helicopters Services Job Number: 35475 Part Number: D2647 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion U 87-11-07

W/O:		*	* WORK ORDER CHANGES					-
DATE	STEP	PI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		***************************************	<u>.</u>					
Part No	):	PAR #:	Fault Category:	NCR: Ye	es No DC	A:	Date: _	
		and the same	•	, QA	: N/C Close	ed:	_ Date: _	

NCR:	NCR:			ORK ORDER NON-CONFORMANCE (NCR)							
· · · · · · · · · · · · · · · · · · ·		Description of NC		Corrective Action Section B		Verification Section C	Ammount	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Approval Chief Eng				
		# 1 # 1									
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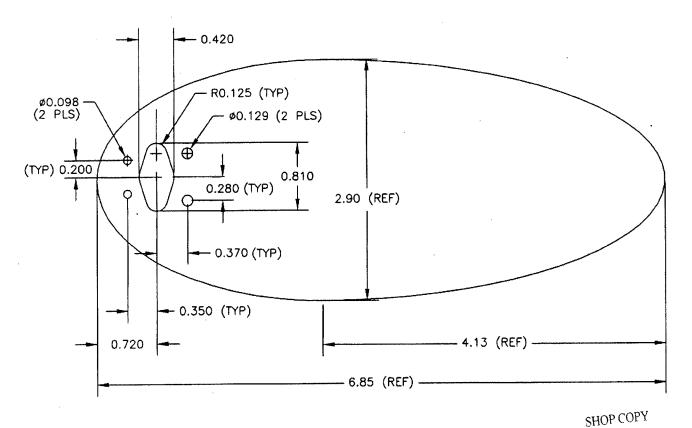




DESIGN	+	DRAWN BY	DART	AEROSPACE BELLEVUE, WA	USA, INC.
CHECK		APPROVED	DRAWING NO.		REV. F
4	t	1 At	D2647		SHEET 1 OF 1
DATE			TITLE		SCALE
00.0	5.26		CAP		NTS
Α		97.03.25	NEW ISSI	JE	



		l l	
00.0	05.26	CAP	NTS
Α	97.03	3.25 NEW	ISSUE
В	97.06	5.27 CHAN	IGED SHAPE
C	97.09	.15 REMO	OVE FRONT PLATE
D	97.11	.06 ADD	RIVET HOLES
E	98.01	.15 ADD	5052 MATERIAL (TSR A245)
F	00.05	5.26 MAKE	FROM D2794
			Application



THIS PART CAN BE MADE FROM D2794

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

6061-T6 (QQ-A-250/11) OR MATERIAL:

5052-H32 (QQ-A-250/8) 0.080 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	35475
Description: FORWARD CAP	Part Number:	D3647
Inspection Dwg:D3647 Rev: F		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article **Prototype Drawing** Actual Method of Tolerance Accept Reject Comments Dimension Dimension Inspection . 098 1.004-,001 601, 129 100. - 200. + .133-4 .420 OIO. .400 X ,810 018, .010 350 380 aio, 4/\_ OFF. 1730 X ab. ·370 370 ¥ Oio 4/\_ 2.90 050 2.90 6.85 Œ.

Measured by: R	Audited by:	S	Prototype Approval:	
Date: 57-11-5	Date:	A11/05	Date:	Ma

Rev	Date	Change		
Α	20.5		Revised by	Approved
A		New Issue	KJ/JLM	
			I I TO TO LIVE	! !



Thursday, 16/11/2006 9:44:03 AM

User:

Linda Lacelle

### **Process Sheet**

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

: 29328

**Estimate Number** P.O. Number

: 10724 : NIA

This Issue

: 16/11/2006

S.O. No. : NIM

: NC

Prsht Rev. : INJA First Issue

**Previous Run** 

Type

: SMALL /MED FAB

: 29328

Written By Checked & Approved By

Comment

: Est Rev:D 99.01.25 Est: E

Re-format DM 06.11.15

waterjet

EC

**Drawing Name** 

: FORWARD CAP

**Part Number** 

: D2647

**Drawing Number** 

- D2647 REV F : N/A

**Project Number** 

**Drawing Revision** 

Material **Due Date** 

: 23/11/2006

Qty:

140 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S080

0.1677 sf(s)/Unit Total: 23.4759 sf(s)

Material:6061-T6 QQ-A-250/11 or 5052-H32 QQ-A-250/8 0.080" Thick

FLOW WATER JET

6061-T6 .080 Sheet

m 102723

Batch M100997x14 2. 3478

2.0

WATER JET

1-Cut as per Dwg D2647

Dwg Rev: F

Comment: FLOW WATER JET

Prog Rev: F

M & 12 01

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



l ob



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

DuitA	. Johade									
W/O:			WORK ORDER CHANGES							•
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									`	
Part No	:	PAR #:	Fault Categ	jory:	NCR	R: Yes I	lo DQ	<b>4</b> :	_ Date: _	
						QA: N/	C Close	d:	_ Date: _	<del>.</del>
NCR:			WORK ORDE	ER NON-CONFORM	MANCE	(NCR				
DATE	STEP	Description of NC	of NC Corrective Action		ction B	0: 0	Verific	ation	Approval	Approval
DATE	SILF	Section A	Section A Initial Action Do Chief Eng Chief				Sign & Section C		Chief Eng	QC Inspector
				•						
										1

Date:

Thursday, 16/11/2006 9:44:03 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD CAP

Job Number: 29328

Part Number: D2647

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_\_\_

QC21



8.0

Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



C Low 12104

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGES	)				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·									
Part No	:	PAR #:	Fault Cate	egory: N					·
					QA: N	1/C Close	d:	_ Date: _	
NCR:		- 1	WORK ORD	DER NON-CONFORMANO	CE (NCF	₹)			
		Description of NC		Corrective Action Section B	·	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
							,		

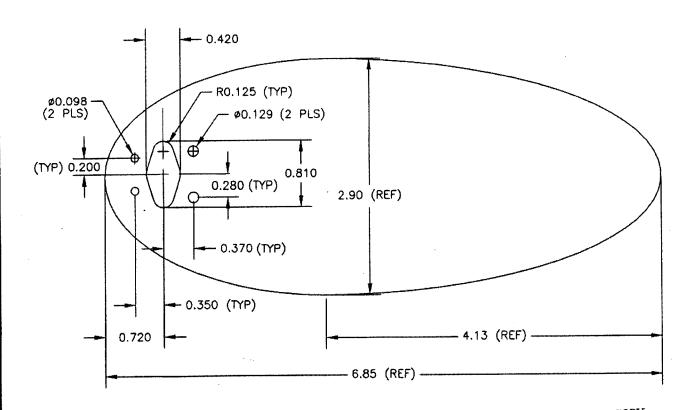




	DESIGN	DRAWN BY	DART AEROSE	PACE USA, INC.
	CHECKED	APPROVED	DRAWING NO.	REV. F SHEET 1 OF 1
	DATE		TITLE	SCALE
	00.05.26		CAP	NTS
-	А	97.03.25	NEW ISSUE	



oc	0.05.26		CAP	NTS
Α		97.03.25	NEW ISSUE	
В		97.06.27	CHANGED SHAPE	***************************************
C		97.09.15	REMOVE FRONT PLATE	
D	)	97.11.06	ADD RIVET HOLES	
E		98.01.15	ADD 5052 MATERIAL (TSR A245)	
F		00.05.26	MAKE FROM D2794	



THIS PART CAN BE MADE FROM D2794

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

6061-T6 (QQ-A-250/11) OR MATERIAL:

5052-H32 (QQ-A-250/8) 0.080 THICK WORK OF STATED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	29328
Description: Forward CAD	Part Number:	D2647
	•	
Inspection Dwg: D&647 \ Rev: F		Page 1 of

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article		X Proto	type
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	1		· I	
\$0.098	10.004,0.001	0.100	11		YerN	
\$0.129	+0.005 - 0.001	0.129	1		Vern	
2,90	11-0.030	2.906	V		Vern	
0.810	4-0.010	0.811	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		WENTY.	
0,420	+1-0.010	0.421	/	-	Vern	;
0.720	1+1-0.010	0.720	1		vern	
0.370	0.010	0.372	1		Hight GUA	re
0.350	+1-0.010	0.353	1		Hight Guna	77
RO.125	+1-0.010	R 0.125	J		RADIUS GUA	
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Measured by: M.:M	Audited by:	Prototype Approval:	
Date: 06 A 01	Date: 06 12 01	Date:	

Rev	Date Change	Revised by	Approved
Α	New Issue	 KJ/JLM	

Dart Aerospace Ltd. Friday, 11/18/2005 10:10:18 AM Date: User: Linda Lacelle **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : FORWARD CAP Job Number : 24842 **Estimate Number** : 10724 : NIA : D2647 P.O. Number **Part Number** S.O. No. : N/A : 11/18/2005 : D2647 REV F This Issue **Drawing Number** : N/A Prsht Rev. **Project Number** : N/A : MACHINED PARTS First Issue Type **Drawing Revision** : N/A **Previous Run** Material 100 Um: : 12/20/2005 **Due Date** Written By COMMENT BELOW Checked & Approved By COMMENT BELOW : Est Rev:D 99.01.25 Comment **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 1.0 M6061T6S080 6061-T6 .080 Sheet Comment: Qty.: 1.9877 sf(s)/Unit Total: 198.7650 sf(s) Material:6061-T6 QQ-A-250/11 or 5052-H32 QQ-A-250/8 0.080" Thick 2.0 SHEAR SHEAR Comment: SHEAR Cut Blanks: 7.100 X 3.200 3.0 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2647 & Dwg D2647 4.0 INSPECT PARTS AS THEY COME OFF MACHI Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 5.0

> Comment: SECOND CHECK SMALL FAB 1

1. 72 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr 06,01,33



Each

6.0

	WORK ORDER CHANGES								
STEP					Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				;					
		STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr			

PAR #: \_\_\_\_\_ Fault Category: Production / Machine NCR: Yes No DQA: Date: 66.02.07

QA: N/C Closed: Date: 66.02.09 Part No: <u>D2647</u>

NCR:	21	1842 W	ORK OR	DER NON-CONFORMANCI	E (NCR)				
		Description of NC	Corrective Action Section B						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
ostrliz	步3.0	Stack of 7 SCAP. Parts model while madri	Deir	Scrap and Destong and Replace	es odizir	500	OPP	0312.12	
65/12/12	せ3.0	ore stack (7pants) has Slot @ 0.790"instead @ 0.810"	65,12.15 per QS1042	Parts ok		05-12-12	65.12.15 per 05/42	un	
16-01-18		#40(.050) holes were not divilled in caps. Drill bit brake in 1 stack and Machinist didn't notice holes were not clivilled in the remainding Stacks(6). 23 parts scrap. holes are messed up in towarsized.	BAN	Cle co D2680-04/nut pinte to cap and and manually As per ang Scrap and destroy chamogedports.  Machinists to Inspect parts as they come off the C.N.C.: to check tooks for chamage.	cell	206-206	@ 950-0	a. 01-18	

Date: User: Friday, 11/18/2005 10:10:18 AM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: FORWARD CAP** 

Job Number: 24842

Part Number: D2647

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

7.0

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: LG



Job Completion



Inspection Level 21 Suc ob/oz/og

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
•				,							
				-							
						·					
Dort No		DAD # . Foult Cotomon	· • · · ·	N- DO		D - 4 -					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

1	WORK ORDER NON-CONFORMANCE (NCR)							
·	Description of NC	Corrective Action Section B			Varification	A		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
						·		
						. ,		
				d.				
					·			
	STEP	STEP Description of NC Section A	STEP Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Chief Eng Chief Eng Sign & Date	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Section A Section A Section C S	

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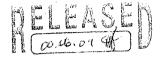
### Job Costing Report

	Job	Costing R	eport		•
Dart Aerospace Ltd.				Nov 17, 200	5
Hawkesbury				03:30 pm	
-				-	
Work Order No :	0024842				
	D2647		Department Code	٠ <u>٠</u>	
ii -	WK550		Burden Flags	: NNNNNNN	
_	Main		WO Status		•
<del></del>	Maili			: Open : Not Invoic	~ d
Main WO Number :	20042		Invoice State	: NOT THAT	ea
House Part Number:		•	Invoice Date	•	
Description : Cap		•	Invoice Number		•
Manufactured : Yes			Invoice Amount	: 0.00	
Amount Req'd:	100		•		•
Amount Done :	0		Order Entry No	:	
Start Date :	11-17-05		OE Value	: 0.00	
Est Finish Date :	12-20-05				
Act Finish Date :			Est Margin	: 0.000%	
Drawings Reqd :	No		Actual Margin	: 0.000%	
Ok for Approval :			•		
Approval Rec'd :			\$0 Posted to Fi	nished Goods	
TIPPE O VOL 1100 U		*	, , , , , , , , , , , , , , , , , , , ,		
	Estimated	Actual	' Var. % Po	sted To	Post
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Material Cost :	0.00	. 0.00	0.00	0.00	0.00
Engineering Hours:	0.00	0.00	0.00	,	
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
		0.00		0.00	0.00
Packaging Hours :	*		0.00	0 00	0 00
	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	* 4	
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
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Total Cost :	0.00	0.00	0.00		
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Labour Hrs/Amount		0.00	0.00		
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Profits/(Loss)	:	0.00	0.00		<b>;</b> ,



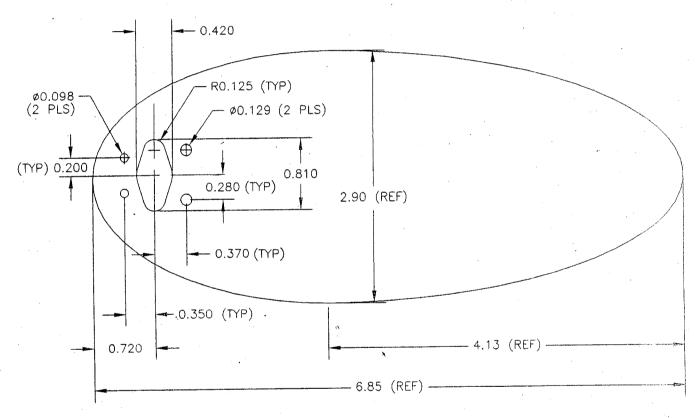


	DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
	CHECKED	APPROVED	DRAWING NO.	REV. F SHEET 1 OF 1
	DATE		TITLE	SCALE
	00.05.26		CAP	NTS
_				•



00.	05.26	CAP
А	97.03.25	NEW ISSUE
В	97.06.27	CHANGED SHAPE
С	97.09.15	REMOVE FRONT PLATE
D	97.11.06	ADD RIVET HOLES
Ε	98.01.15	ADD 5052 MATERIAL (TSR A245)
F	00.05.26	MAKE FROM D2794

COMTROL E



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR

5052-H32 (QQ-A-250/8) 0.080 THICK

TOLERANCES ARE PER' DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	24842
Description: CIAP		
Description: CAP	Part Number:	D2647
Inspection Dwg: 57/14 Pay: C		
Inspection Dwg: D2647 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
,		First Arti	cle	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
6.85	10.030	6.846					
Q.720	+ 0.000	0.717					
0.470	+ 0.010	0.424	2				r all I i de l'ange parer en parliculation en manuel et en experience de l'année de manuel et en parenne
6.810	+0000	0.80					
\$ 0.098	+ 0.005 + 0.005	0.100	-				CONTROL OF THE CONTRO
\$ 0.129	+ 0.005	0.129					
2.50	±0.030	2.900	-				
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Measured by:	En	Audited by:	<b>1</b> 8	Pro	ototype App	proval:	
Date:	67/12/12		5/12/12			Date:	
Rev Date	Change					lauta a la	
A New Issue Revised by Approved KJ/RF					Approved		

```
Re D2647 Cap.txt
From: David Shepherd [davids@dartaero.com]
Sent: December 15, 2005 3:25 PM
To: Chris Provencal
Subject: Re: D2647 Cap
As long as the nutplate fits through, I think they are good. I would accept
them.
FYI, I never got this because my email never got changed to
dshepherd@dartaero.com.
David
---- Original Message ----
From: "Chris Provencal" <cpre>cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Thursday, December 15, 2005 1:10 PM
Subject: RE: D2647 Cap
> Any word on this?
   ----Original Message----
> From: Chris Provencal [mailto:cprovencal@dartaero.com]
> Sent: December 12, 2005 2:19 PM
> To: 'dshepherd@dartaero.com'
  Subject: D2647 Cap
> David,
> D2647 Cap, that's the front cap for the 206 skidtubes, the 0.810"
```

> for the width of the slot for the MS21069L4 nutplate is 0.790" for about 7

> I'm thinking they're OK, but they should check when assembling that > everything fits together OK. They can always widen the slot if need be.

> everything fits together OK.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax......613-632-4443

parts.